

Work Order ID 72908

Wednesday, August 17, 2011 2:49:52 PM



Page 1

Item ID: D4278-041

Accept



Setup Start



Revision ID:

Item Name: Upper Rib Assembly-Hoop

Stop



Start Date: 8/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-08-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4034

B

D4278

C

100

Weld per dwg A/R S.S. rod Batch: 117884 0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT

2- Weld bushing in rib and grind weld flush as per dwg

PL 11-08-23

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-08-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11.08.24

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

STOCK IN BASKET CELL



11.08.24

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/24

11-08-24
(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 17, 2011 2:49:58 PM

Page 1

Work Order ID: 72908

Parent Item: D4278-041

Parent Item Name: Upper Rib Assembly-Hoop



Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4021-7 		Manufactured	No			100	Each	1.0000	1	1			
Hoop													

Location

Loc Qty

Loc Code

WA005

1

71743

1

D4021-9 		Manufactured	No			100	Each	126.0000	4	4			
Bushing													

Location

Loc Qty

Loc Code

WA

124

70333

60

72482

64

WA005

2

66437

2

D4034-1 		Manufactured	No			100	Each	11.0000	1	1			
Rib													

Location

Loc Qty

Loc Code

WA

11

67334

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 17, 2011 2:49:58 PM

Page 2

Work Order ID: 72908



Parent Item: D4278-041



Parent Item Name: Upper Rib Assembly-Hoop

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

D4034-3

Manufactured No

100

Each

5.0000

1



Rib



Pl 11-08-22

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	5	
58408	0	
67338	2	
72253	3	

1

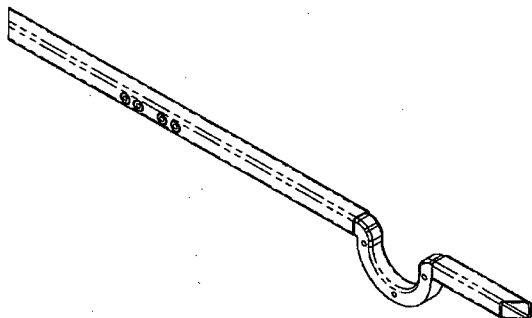
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

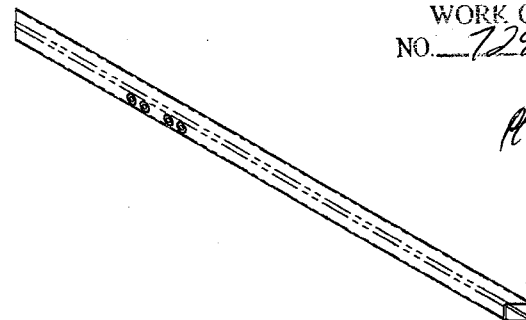
NOTE: Date & initial all entries



D4278-041 UPPER RIB ASSY-HOOP



D4278-045 RIB ASSY, FWD CHAM



D4278-047 UPPER RIB ASSY-STRAIGHT



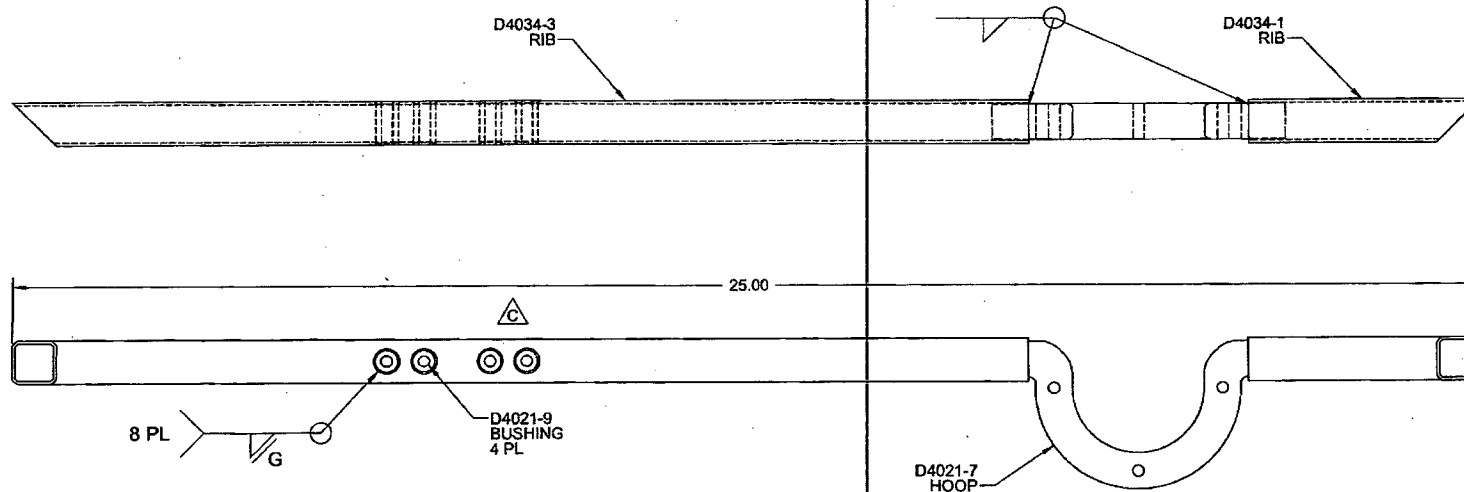
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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72908

111-08-17

RELEASED
2011-01-18
MM

C	ADDITIONAL HOLES ADDED IN D4278-041-047	SC	10.12.23
B	RMV -043 (OBSOLETE)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4278	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSEMBLY	NTS
DATE	10.12.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COPIED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY -041	PART NUMBER	DESCRIPTION
		D4278-041	UPPER RIB ASSY-HOOP
1	1	D4021-7	HOOP
2	4	D4021-9	BUSHING
3	1	D4034-1	RIB
4	1	D4034-3	RIB



D4278-041 UPPER RIB ASSY-HOOP

72208

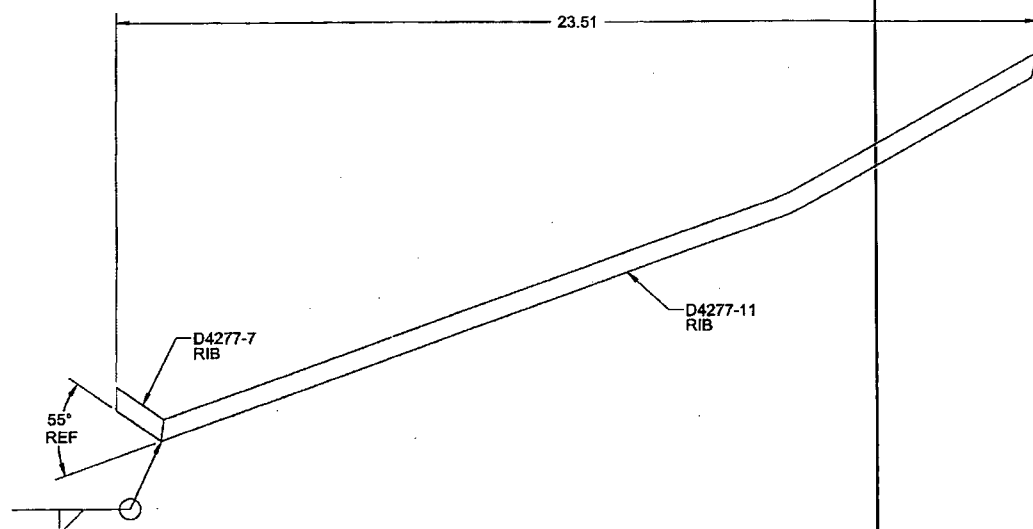
RELEASED
R 2011-01-18 D

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	JRH	DART AEROSPACE LTD	
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MFG. APPR.		D4278	SHEET 2 OF 4
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ITEM	QTY	PART NUMBER	DESCRIPTION
	1	D4278-045	RIB ASSY, FWD CHAM
1	1	D4277-7	MID CORNER RIB, NOTCH
2	1	D4277-11	MID DIAG RIB



D4278-045 RIB ASSY, FWD CHAM

12208

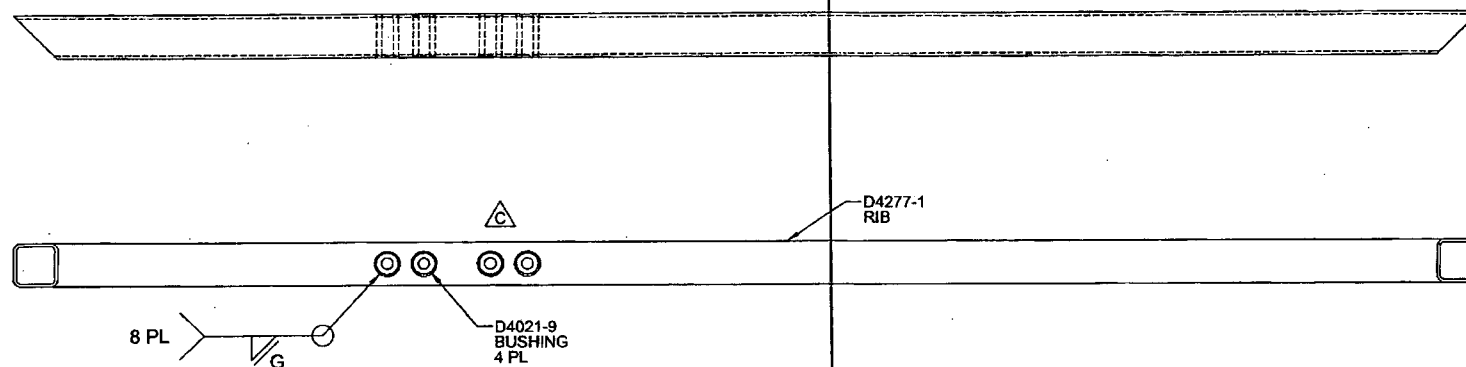
RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs
- 8) WELD PER DART QSI 004.

DESIGN	JRH	DART AEROSPACE LTD	
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DE APPR.		RIB ASSEMBLY	NTS
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ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-047	UPPER RIB ASSY-STRAIGHT
1	4	D4021-9	BUSHING
2	1	D4277-1	RIB



D4278-047 UPPER RIB ASSY-STRAIGHT

72908

RELEASED
2011-01-10
MA

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.95 lbs
- 8) WELD PER DART QSI 004.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4278	SHEET 4 OF 4
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